

Work Order ID 86039

June-19-12 4:09:02 PM

86039

Page 1

Item ID: D3782-045

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Back Leg Assembly

Start Date: 19/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3782	Rev B								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Small Fab	0.00							
Small Fab	Memo								
Small Fab	1-assemble as per dwg D3782								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

2 0 FF 12-06-27

2 0 FF 12-06-27

(72)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86039

June-19-12 4:09:02 PM

86039

Page 2

Item ID: D3782-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Back Leg Assembly

Start Date: 19/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location

C.A.

0.00

130

Packaging

Memo

0.00

Packaging

*2x**12/06/29*

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

*MLJ 12/06/29**MF 12-06-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-19-12 4:09:06 PM

Page 1

4

Work Order ID: 86039

86039

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C
10.02.22 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3772-1		Manufactured	No			110	Each	2.0000	1	2			

D3772-1

Back Leg

**

② FF 12-06-27

Location Loc Qty Loc Code

ST254 2

67361 2

D3787-1 Manufactured No

110 Each 22.0000 1 2

D3787-1

Foot

**

② FF 12-06-27

Location Loc Qty Loc Code

ST249A 22

82250 12

83820 10

D3764-1 Manufactured No

110 Each 7.0000 1 2

D3764-1

Back Leg Fitting

**

② FF 12-06-27

Location Loc Qty Loc Code

ST243 74065 7

81699 1

85279 6

D3773-041 Manufactured No

110 Each 0.0000 1 2

D3773-041

Headrest Assembly

**

2 ② FF 12-06-27

B 85282

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-19-12 4:09:06 PM

Page 2

Work Order ID: 86039

86039

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 2.00

Required Qty: 2.00

D3786-1

Manufactured No

110

Each

6.0000

1

2

D3786-1

Sleeve

**

② FF 12-06-27

Location

Loc Qty

Loc Code

ST249

6

81673

6

2

AN45-15A

Purchased

No

110

Each

16.0000

1

2

AN45-15A

EYE BOLT

**

② FF 12-06-27

Location

Loc Qty

Loc Code

ST362

16

115908

6

122012

10

2

AN5-15A

Purchased

No

110

Each

193.0000

1

2

AN5-15A

Bolt

**

② FF 12-06-27

Location

Loc Qty

Loc Code

ST338

193

115159

43

115316

50

121181

100

2

AN5-17A

Purchased

No

110

Each

60.0000

1

2

AN5-17A

Bolt

**

② FF 12-06-27

Location

Loc Qty

Loc Code

338

4

121181

4

ST338

56

117872

34

121541

22

2

June-19-12 4:09:06 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-19-12 4:09:06 PM

Page 3

Work Order ID: 86039

86039

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 2.00

Required Qty: 2.00

AN4-15A

Purchased

No

110

Each

370.0000

2

4

AN4-15A

Bolt

**

② FF 12-06-27

Location

Loc Qty

Loc Code

358

100

121652

100

GA

100

120449

100

ST358

170

118706

3

120422

1

121541

166

2

MS21042L4

Purchased

No

110

Each

2,875.000

2

4

MS21042L4

Nut

**

② FF 12-06-27

Location

Loc Qty

Loc Code

ST300

2875

119075

116

121011

193

121444

2266

121652

300

7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-19-12 4:09:07 PM

Page 4

Work Order ID: 86039

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly

86039

D3782-045

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

110

Each

1,335.000

3

6

MS21042L5

Nut

**

② FF 12-06-27

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

835

108827

4

116105

5

116548

43

117611

18

119109

749

17651

8

2937

8

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

4

8

AN960.ID416

Washer

**

② FF 12-06-27

Location

Loc Qty

Loc Code

ST351

121912

30

116289

10

119097

20

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

16.0000

5

10

AN960.ID516

Washer

**

② FF 12-06-27

Location

Loc Qty

Loc Code

ST338

119546

16

2612

16

10

June-19-12 4:09:07 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

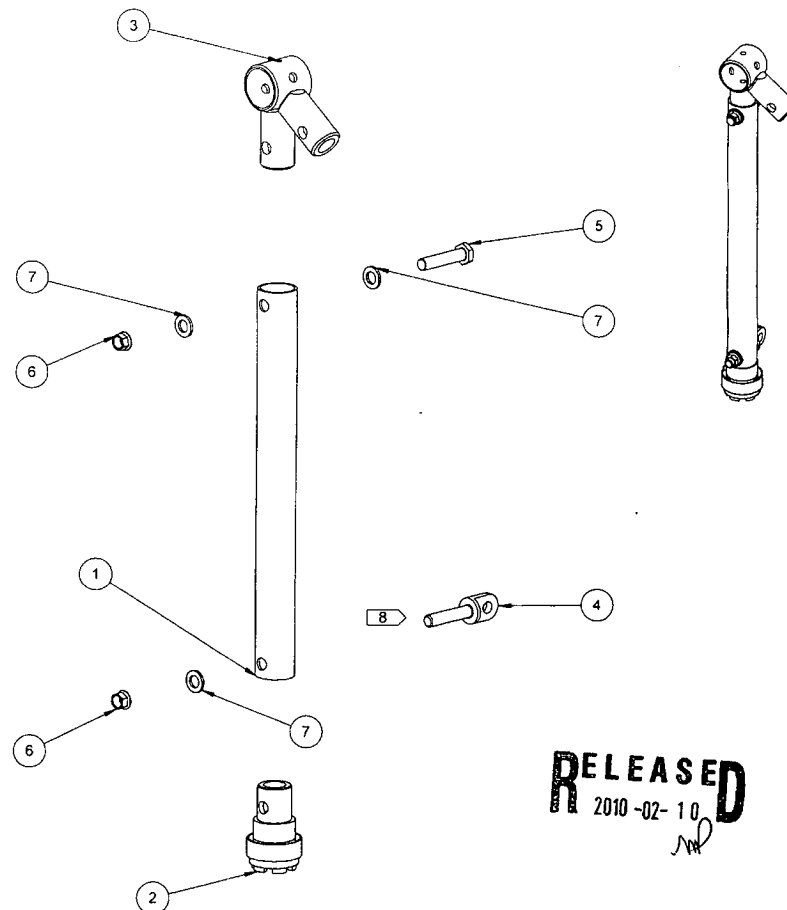
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. (-041)	PART NUMBER	DESCRIPTION
1	1	D3768-1	FRONT INBOARD LEG
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	1	AN45-13A	EYE BOLT
5	1	AN5-13A	BOLT
6	2	MS21042L5	NUT
7	3	NAS1149D0563J	WASHER (AN960JD516)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86039 MCT
12/06/20



D3782-041 FRONT INBOARD LEG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) ITEM 4 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

RELEASED
2010-02-10
nm

B	REVISE P/N NAS1149D0568J TO NAS1149D0563J ALL SHEETS, ZN D7	10.01.21
A	NEW ISSUE	08.06.04
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.01.21	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3782** REV. B
SHEET 1 OF 4
TITLE **LEG ASSEMBLY** SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

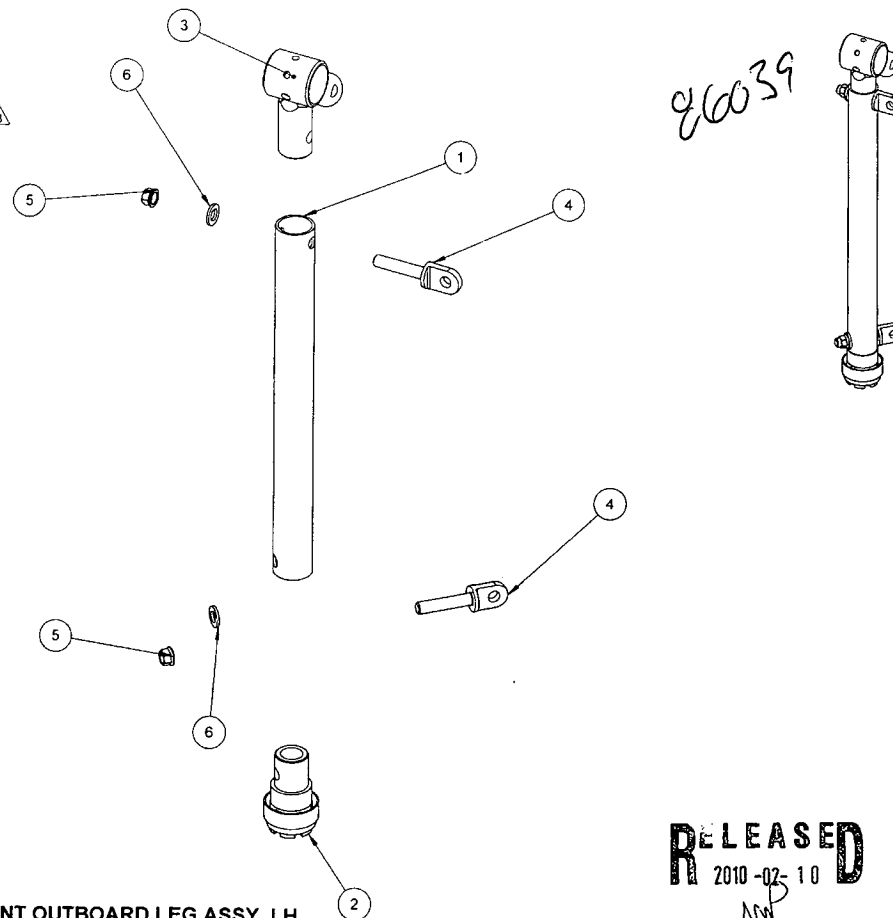
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. (-043)	PART NUMBER	DESCRIPTION
1	1	D3768-3	FRONT OUTBOARD LEG, LH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



D3782-043 FRONT OUTBOARD LEG ASSY, LH

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3782	REV. B
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE LEG ASSEMBLY	SCALE NTS
DE APPR.			
DATE	10.01.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

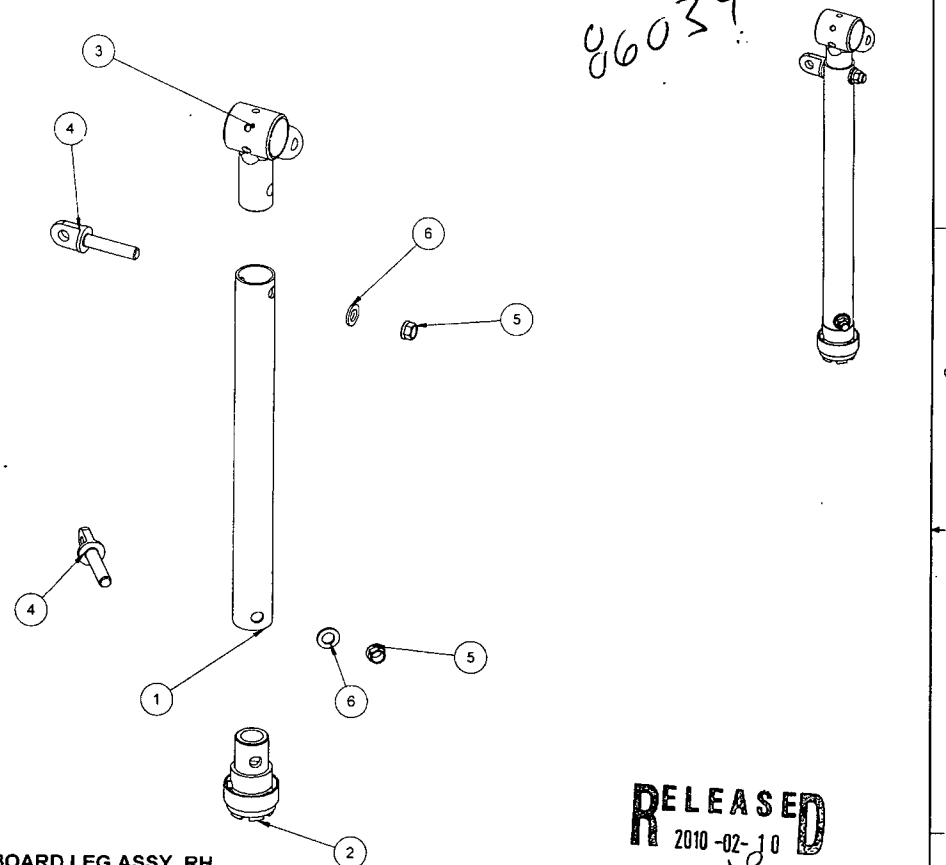
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. (-044)	PART NUMBER	DESCRIPTION
1	1	D3768-4	FRONT OUTBOARD LEG, RH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



D3782-044 FRONT OUTBOARD LEG ASSY, RH

RELEASED
2010-02-10

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3782	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LEG ASSEMBLY	NTS
DATE	10.01.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

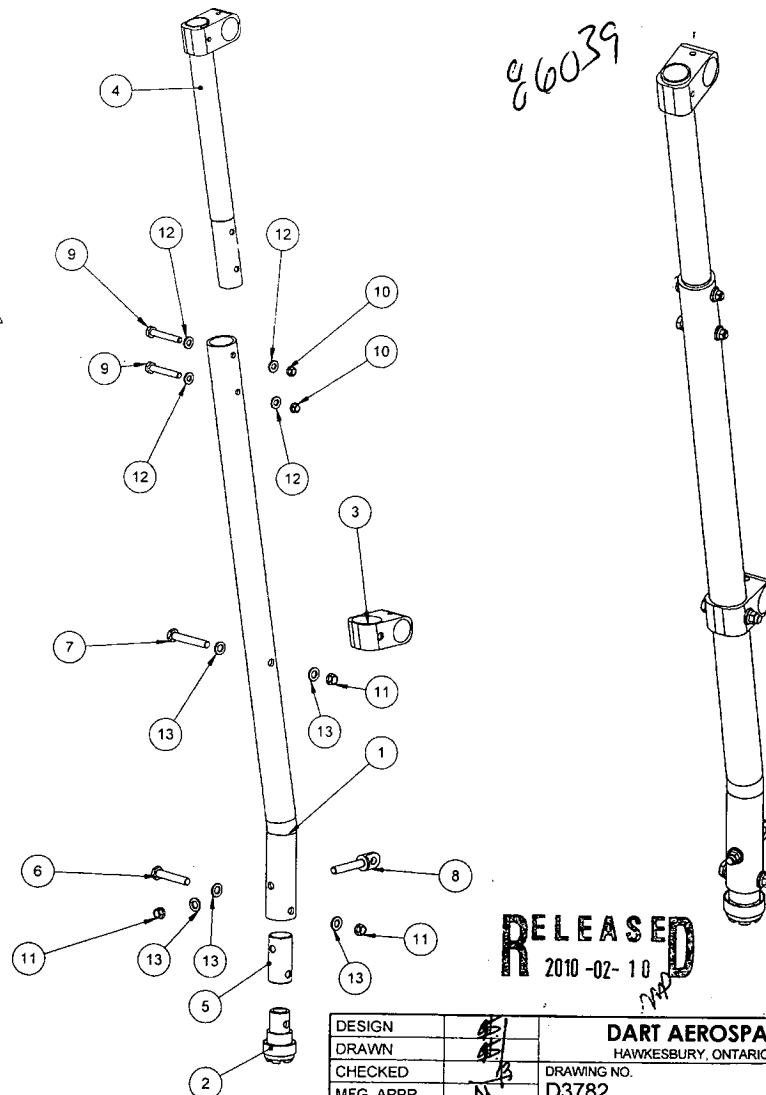
NOTE: Date & initial all entries

ITEM NO.	QTY. (-045)	PART NUMBER	DESCRIPTION
1	1	D3772-1	BACK LEG
2	1	D3787-1	FOOT
3	1	D3764-1	BACK LEG FITTING
4	1	D3773-041	HEAD REST ADAPTER ASSY
5	1	D3786-1	SLEEVE
6	1	AN5-15A	BOLT
7	1	AN5-17A	BOLT
8	1	AN45-15A	EYE BOLT
9	2	AN4-15A	BOLT
10	2	MS21042L4	NUT
11	3	MS21042L5	NUT
12	4	NAS1149D0463J	WASHER (AN960JD416)
13	5	NAS1149D0563J	WASHER (AN960JD516)

D3782-045 BACK LEG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.71 lbs



RELEASED
2010-02-10

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3782	REV. B
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE LEG ASSEMBLY	SCALE
DE APPR.			NTS
DATE	10.01.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries